

Work Order ID 134864

Wednesday, July 22, 2015 4:14:08 PM

134864

Page 1

Item ID: D5123-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Clamp Cushion

Start Date: 7/19/15 Start Qty: 10.00

10

Cust Item ID:

Required Date: 7/22/15 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: MLS Date: JUL 23 2015

Tooling:

Date:

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D5123	C								

100

0.00

100

Mill Conv

Memo

0.00

Conventional Milling Machine

1-Mill as per DWG

DWG REV: C

2-Deburr as required

10 0 J.L.L. 15/09/01

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

10 0 J.L.L. 15/09/01

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Work Order ID 134864

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Item ID: D5123-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Clamp Cushion
 Start Date: 7/19/15 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 7/22/15 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120	QC8- Inspect parts - second check	0.00							
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120

QC Memo

Quality Control

DAS

14

9-89

15/09/02

130	Identify as per dwg & Stock Location LG053	0.00							
-----	---	------	--	--	--	--	--	--	--

130

Packaging Memo

Packaging LOCATION : LG055

10 DAS
27
9-89

SEP 03 2015

140	QC21- Final Inspection - Work Order Release	0.00							
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140

QC Memo

Quality Control

15/9/3

51120150903

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
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Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER : _____							

Picklist Print

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Work Order ID: 134864

134864

Parent Item: D5123-1

D5123-1

Parent Item Name: Clamp Cushion

Start Date: 7/19/15

Required Date: 7/22/15

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP REV:A NEW ISSUE 14/08/08 JLM VERIFIED BY:RQ

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4287-1		Manufactured	No				f	44.5520		4.315789			

D4287-1

Uhmw U-Channel

Location

Loc Qty

Loc Code

ST479a

44.552

133932

44.552

4.3281 J.C.L. 18/08/20

DQA: _____ Date: _____



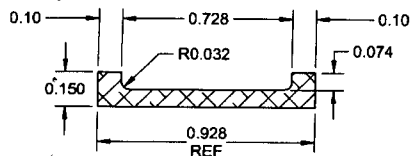
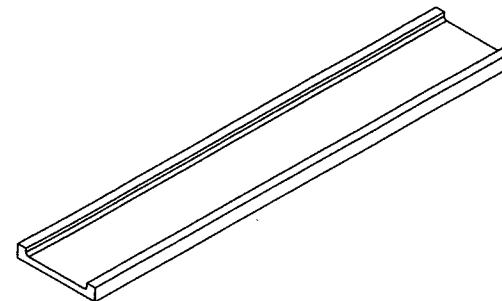
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

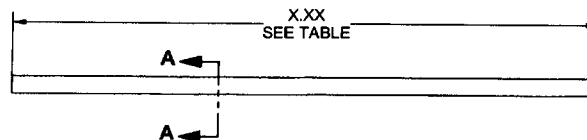
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OTHER : ☐					

8 7 6 5 4 3 2 1



SECTION A-A
SCALE 2X



D5123-Y CLAMP CUSHION

PART NUMBER	LENGTH X.XX (IN)
D5123-1	5.00
D5123-3	4.25
D5123-5	6.00
D5123-7	3.95



SHOP COPY
RETURN TO
ENGINEER
UNCONTROLLED
SUBJECT TO

WILLIAM
W.D.
NO 134864
ML5

1507-23

RELEASE

2015 MAR 18

ECN 15-547

- NOTES:**
 1) MATERIAL: MAKE FROM D4287-1
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: IDENTIFY PER QSI 044 METHOD 6.7
 7) WEIGHT: LESS THAN 0.01 lbs

C	ADD D5123-7	CP	15.01.21
B	ADDED D5123-5 CLAMP CUSHION, ADDED TABLE, ADDED THICKNESS TO PART	AP	14.08.19
A	NEW ISSUE	AP	14.08.08
REV.	DESCRIPTION	BY	DATE
DESIGN	AP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	CP		
CHECKED	AP	DRAWING NO.	REV. C
MFG. APPR.	JLM	D5123	SHEET 1 OF 1
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	CLAMP CUSHION	NTS
DATE	15.01.21	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

APPROVED

8 7 6 5 4 3 2 1